

Date: Tuesday, 16/10/2007 7:11:58 AM  
 User: Linda Lacelle

2 hrs  
1:30

## Process Sheet

|                       |  |                  |                               |
|-----------------------|--|------------------|-------------------------------|
| Customer              | CU-DAR001 Dart Helicopters Services  | Drawing Name     | : WEB                         |
| Job Number            | : 35172  |                  |                               |
| Estimate Number       | : 10498  |                  |                               |
| P.O. Number           | : N/A  | Part Number      | : D2739                       |
| This Issue            | : 16/10/2007 S.O. No. : N/A  | Drawing Number   | : D2739 REV D                 |
| Prsht Rev.            | : NC   | Project Number   | : N/A                         |
| First Issue           | : N/A  | Drawing Revision | : D                           |
| Previous Run          | : 33421  | Material         | : N/A                         |
| Written By            | :  | Due Date         | : 23/10/2007 Qty: 10 Um: Each |
| Checked & Approved By | :  |                  |                               |
| Comment               | Est Rev: C 02/11/28 Reformat KJ<br>Est Rev: D 08-03-21 As Per Rev C JLM<br>Est Rev: E 07-07-28 As per Rev D JLM Verified By: |                  |                               |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :  |
|---------|-----------------------|--|
| 1.0     | D26005108             | Extrusion 'I Beam' thin  |
|         |                       |  |
|         |                       | Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)<br>Extrusion 'I Beam' thin<br>Pick:<br>Qty Part Number Description Batch<br>1 D2600-5 Web 29985   |
| 2.0     | LANDING GEAR 1        | LANDING GEAR RESOURCE 1  |
|         |                       |  |
|         |                       | Comment: LANDING GEAR RESOURCE 1<br>1-Cut D2600-5 to length as per Dwg D2739.<br>2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739<br>3-Use uni-bit to open holes to finish size as per Dwg D2739.<br>4-Bevel Fwd end of extrusion and Deburr holes and ends.<br>5-Dburr |
| 3.0     | QC5                   | INSPECT WORK TO CURRENT STEP   |
|         |                       |  |
|         |                       | Comment: INSPECT WORK TO CURRENT STEP  |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/01/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 16/10/2007 7:11:58 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 35172

Part Number: D2739

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SL 7-10-17

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 7-10-17 10

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock  
Location: LG

SL 7-10-17 10

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DP 10/10/17

Job Completion



U 8/10/17

W/O:

## WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|------|------|------------------|----|------|-----|-------------------------------------|--------------------------|
|      |      |                  |    |      |     |                                     |                          |
|      |      |                  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

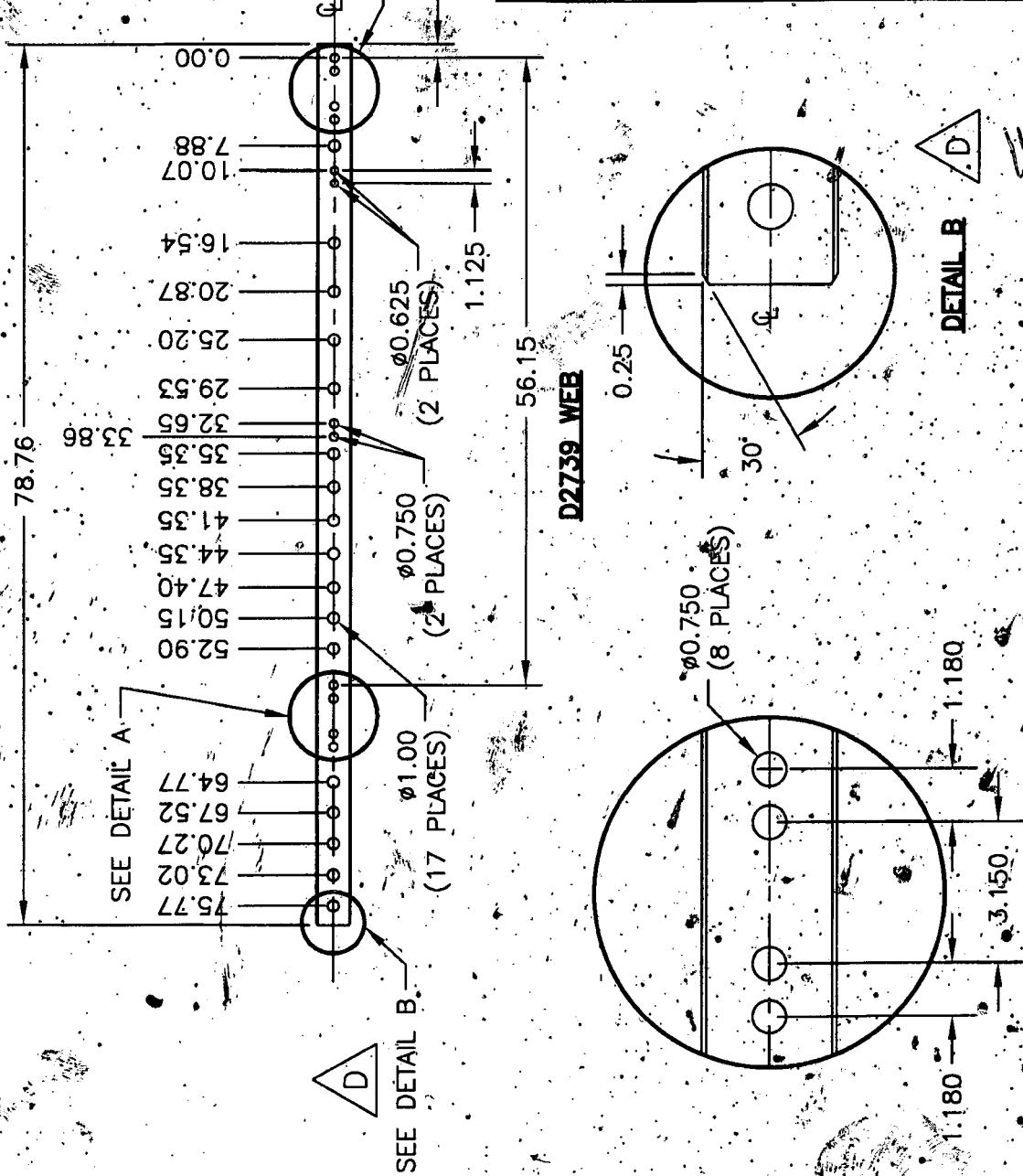
NOTE: Date &amp; initial all entries

**DART**

**RELEASED**

02.08.98

|                      |                       |  |
|----------------------|-----------------------|--|
| DESIGN<br><i>PH</i>  | DRAWN BY<br><i>CB</i> | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA.            |
| CHECKED<br><i>PH</i> | APPROVED<br><i>PH</i> | DRAWING NO.<br>D2739                                     |
| DATE<br>07.05.29     |                       | TITLE<br>WEB   |
|                      |                       | SCALE<br>1:15  |
| A                    | 98.04.16              | NEW ISSUE  |
| B                    | 98.11.18              | CHANGE HOLES FOR COMPATABILITY<br>WITH AIRCRUISER FLOATS |
| C                    | 06.01.05              | ADD/MOVE HOLES FOR COMPATABILITY<br>W/APICAL FLOATS      |
| D                    | 07.05.29              | ADD BEVEL TO FWD END; ADD DETAIL B                       |



NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005-4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT C

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